

Date: Wednesday, 1/31/2007 2:44:43 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH
Job Number	: 30525		
Estimate Number	: 10197		
P.O. Number	: <i>N/A</i>	Part Number	: D350607041
This Issue	: 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 30524	Material	: <i>N/A</i>
Written By	:	Due Date	: 2/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>JA 07.02.01</i>		
Comment	: Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-041 CHG006

KS 07.02.08

2.0	30525A	BASKET BASE ASSEMBLY (350)
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Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B *30525A*

3.0	30525B	350/212/130 BASKET LID
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Comment: Sub-Component 350/212/130 BASKET LID
D2512 B *30525B*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick: Assembly Kit

5.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
2 D2022-101 Spacer *B 26664-*

MF 07-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:44:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label B 28312 -

7.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B 30547 -

8.0

D2530

Handle Weldment



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B 30383 -

9.0

D2535

Spring



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B 28363 -

10.0

D2537

Bushing



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B 29536 -

11.0

D27283

Dart Logo label large



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label B 22553 -

mf. 07-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2931

Bumper



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper B21139 -

13.0

AN316A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M101884 -

14.0

AN47A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M102140 -

15.0

AN422A

Bolt



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M100791 -

16.0

AN424A

Bolt



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M101938 -

17.0

AN517A

Bolt



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M102140 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD8

Washer



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer m102842 -

19.0

AN960JD416

Washer



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer m103338 -

20.0

AN960JD416L

Washer



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer m101237 -

21.0

AN960JD516

Washer



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer m102519 -

22.0

AN9704

Washer



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer m103344 -

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet m14393 -

MF 07-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L3

Nut



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) m10 2658 -

25.0

MS21042L4

Nut



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) m103349 -

26.0

MS21042L5

Nut



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) m100564 -

MF 07-03-27

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: m103491

Expiry date: 10/2007

MF 07-03-27

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/03/27

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:44:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D22301

Mounting Lug



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Packing Kit

Qty Part Number

4 D2230-1

Description Batch

Lug

B30155 ✓

31.0

D22303

Mounting Lug



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick: Packing Kit

Qty Part Number

4 D2230-3

Description Batch

Clamp

B30545 ✓

32.0

D23241

Strut Assembly



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick: Packing Kit

Qty Part Number

1 *D2324-1

Description Batch

Strut Ass'y

B30139 ✓ ✓

33.0

D2856400

Abrasion Strip



Comment: Qty.: 1 f(s)/Unit Total : 1 f(s)

Pick: Packing Kit

Qty Part Number

4 D2856-400-720 Abrasion Strip

Description Batch

B29850 ✓ ✓

34.0

AN412A

Bolt



Comment: Qty.: 5 Each(s)/Unit Total : 5 Each(s)

Pick: Packing Kit

Qty Part Number

5 AN4-12A

Description Batch

Bolt

M102029 ✓ ✓

35.0

AN413A

Bolt



Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN4-13A

Description Batch

Bolt

M103363 ✓ ✓

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:44:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30525

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960JD416

Washer



Comment: Qty.: 26 Each(s)/Unit Total : 26 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M103338 ✓ ✓

37.0

MS21042L4

Nut



Comment: Qty.: 13 Each(s)/Unit Total : 13 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M103349 ✓ ✓

07/03/22 59

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/03/28 C207/03/28 ①

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-041

Location:

REV:G

07/03/28 ① / 7/3/28 ①

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

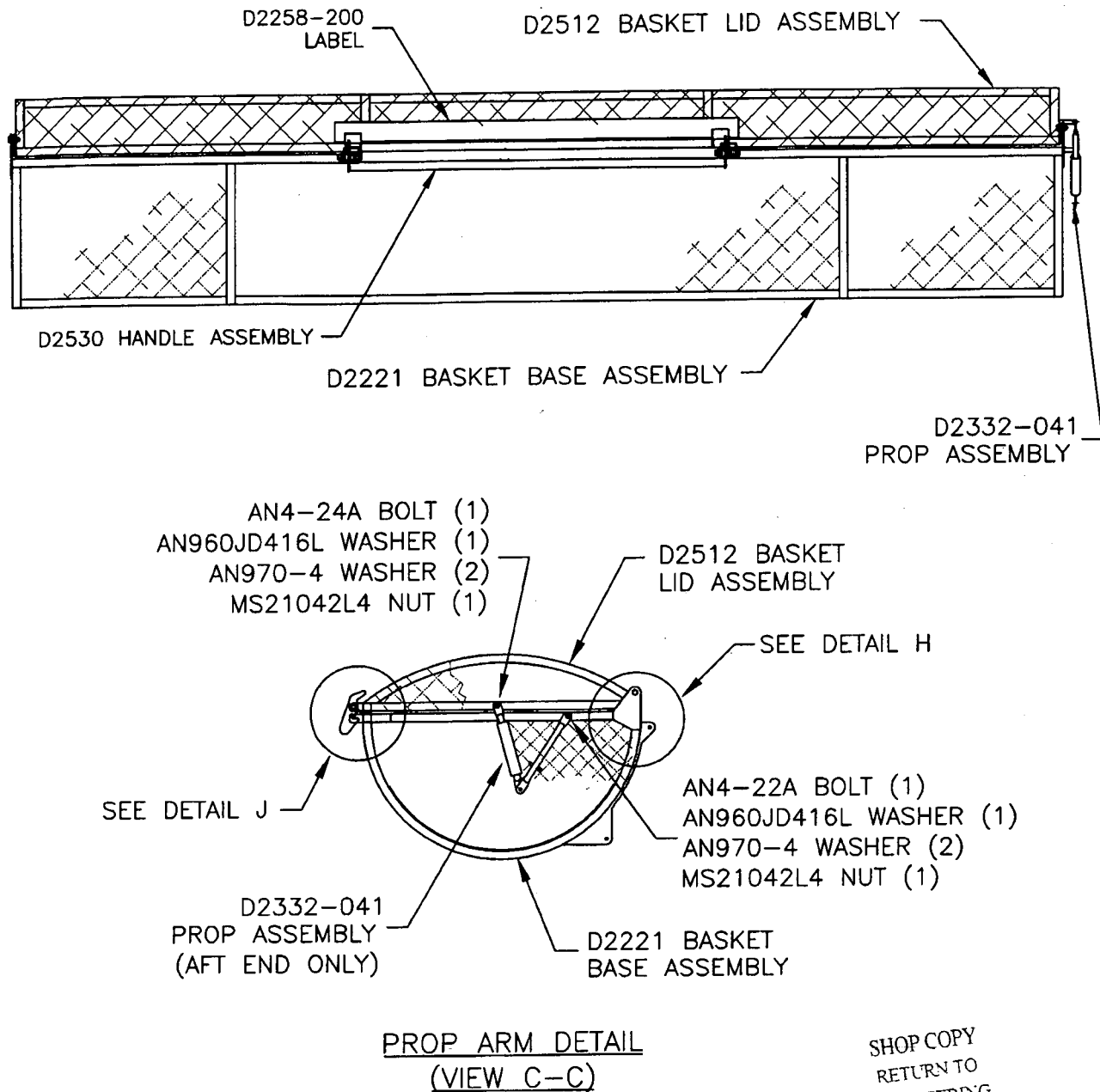


Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30525

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Revision: F
Date: 03.01.17

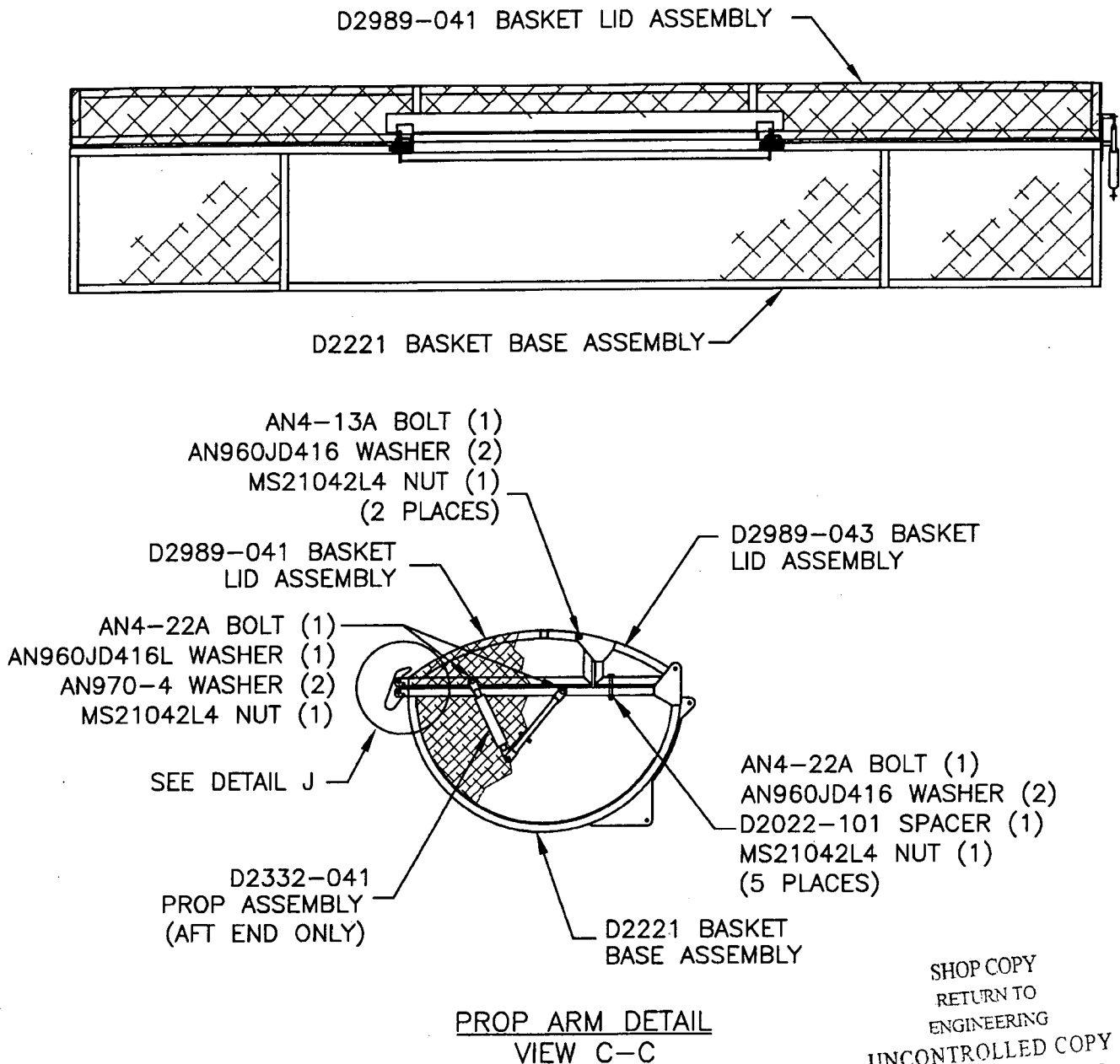
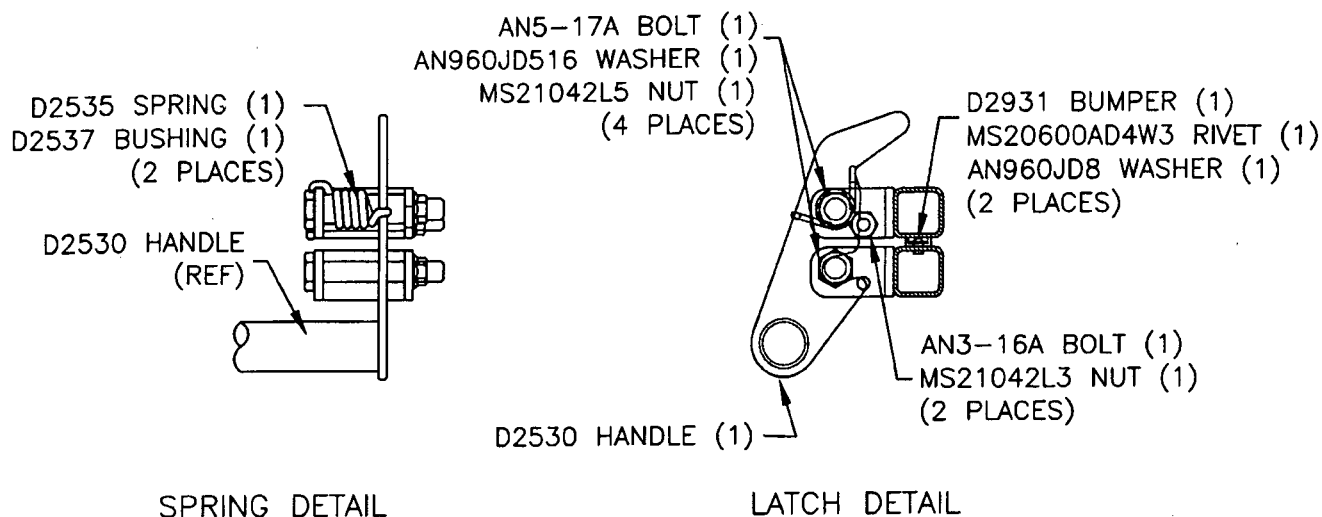


Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

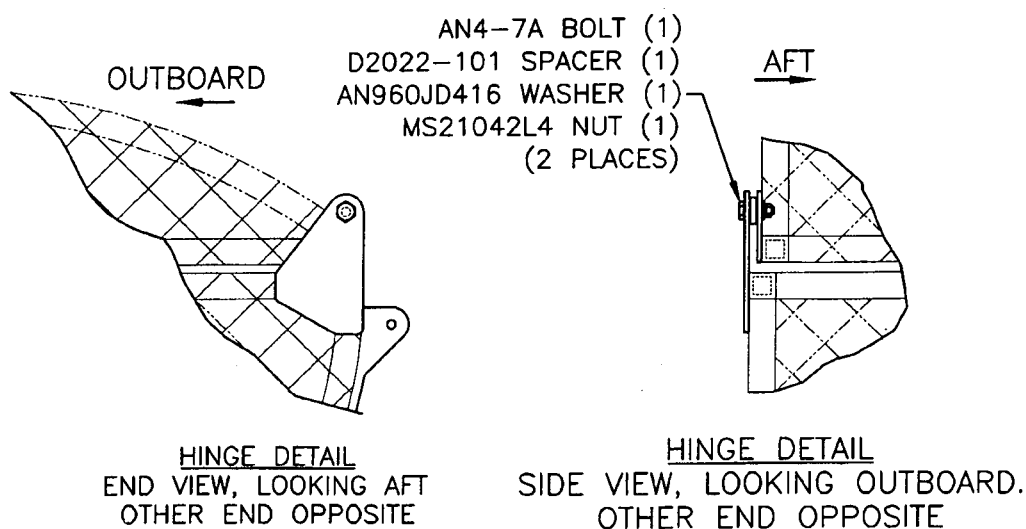
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Revision: **F**
Date: 03.01.17



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30525

Date: Wednesday, 1/31/2007 2:45:05 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY (350)
Job Number : 30525A	
Estimate Number : 10189	
P.O. Number : N/A	Part Number : D2221
This Issue : 1/31/2007 S.O. No. : N/A	Drawing Number : D2221/D2235
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : F/B1
Previous Run : 30524A	Material : N/A
Written By : <u>JA 07.02.01</u>	Due Date : 2/28/2007 Qty: 1 Um: Each
Checked & Approved By : <u>JA 07.02.01</u>	
Comment : Est Rev:J 05.09.02 Added D3442-1 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	<u>B30560</u>

Ppl 07.03.19

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	<u>B29132</u>

Ppl 07.03.19

3.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	<u>B29133</u> → 2
			<u>B30546</u> → 2

Ppl 07.03.19

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	<u>B28597</u>

Ppl 07.03.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:45:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 30525A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B30003

Cpl 07-03-19

6.0

D34421

Shim



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B30564

Cpl 07-03-19

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 42 sf(s)/Unit Total : 42 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal m103645

Cpl 07-03-19

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29 f(s)/Unit Total : 29 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: m102765

Cpl 07-03-19

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

Cpl 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R9 Date: 07/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 30525A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/20

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/03/20

12.0

POWDER COATING

POWDER COATING



M 103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.l 07/03/24

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m.F. 07-03-27 ①

14.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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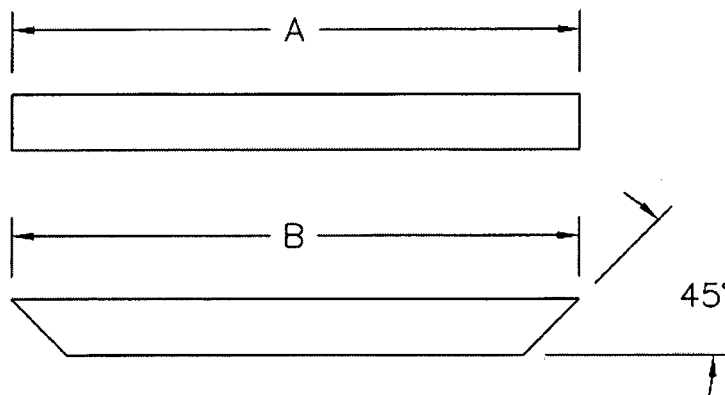
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED05.08.19 *[Signature]*PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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NO. 30626A

D2221-1/-3/-5/-7

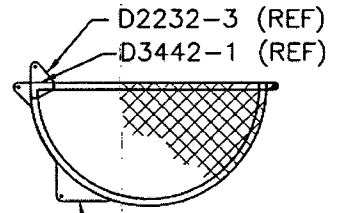
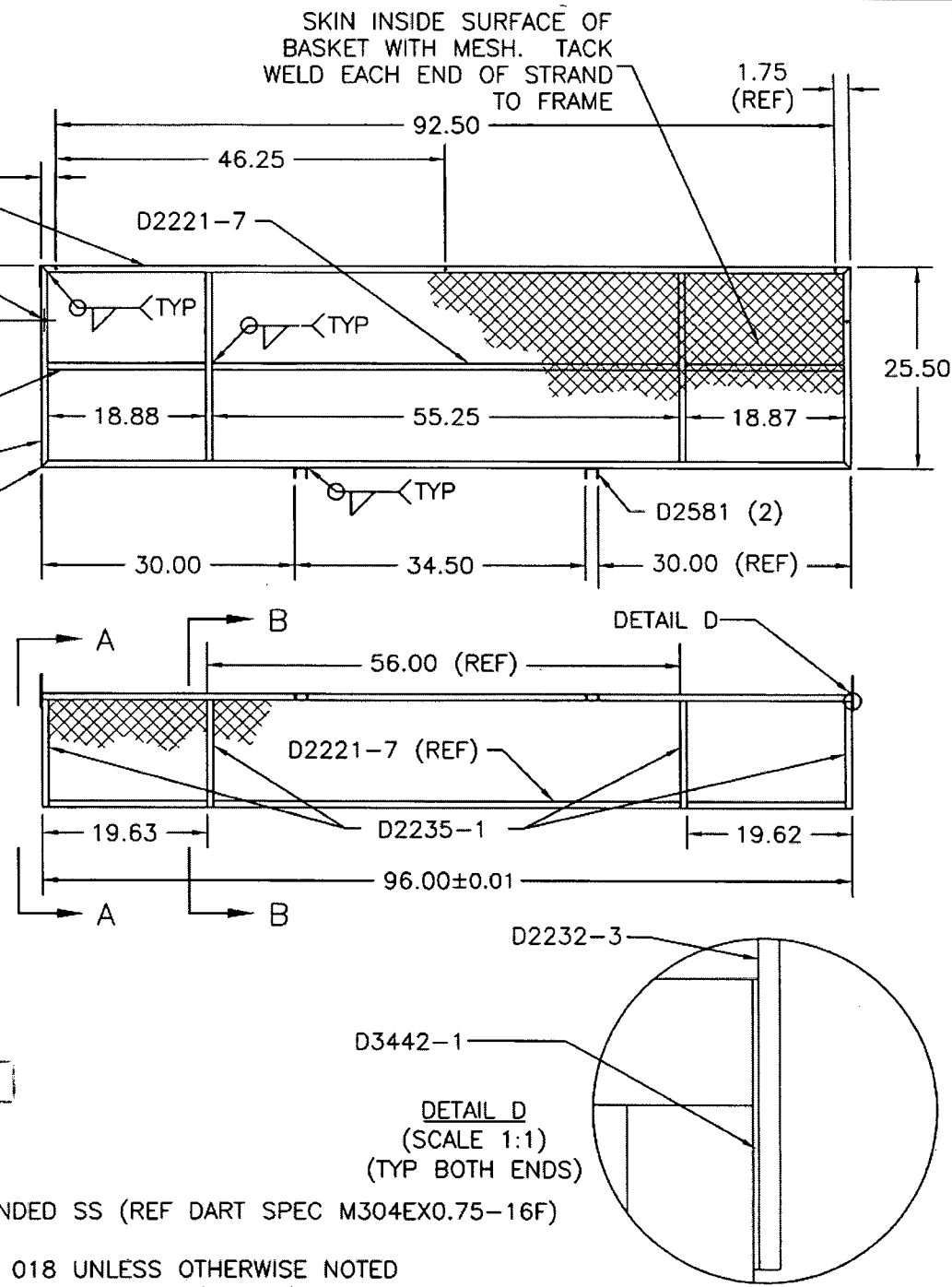
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

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CHECKED		APPROVED		HAMKESBURY, ONTARIO, CANADA
DATE	05.06.07	TITLE	D2221	REV. F
				SHEET 2 OF 3
				SCALE
				1:20



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D2221 BASKET BASE ASSEMBLY

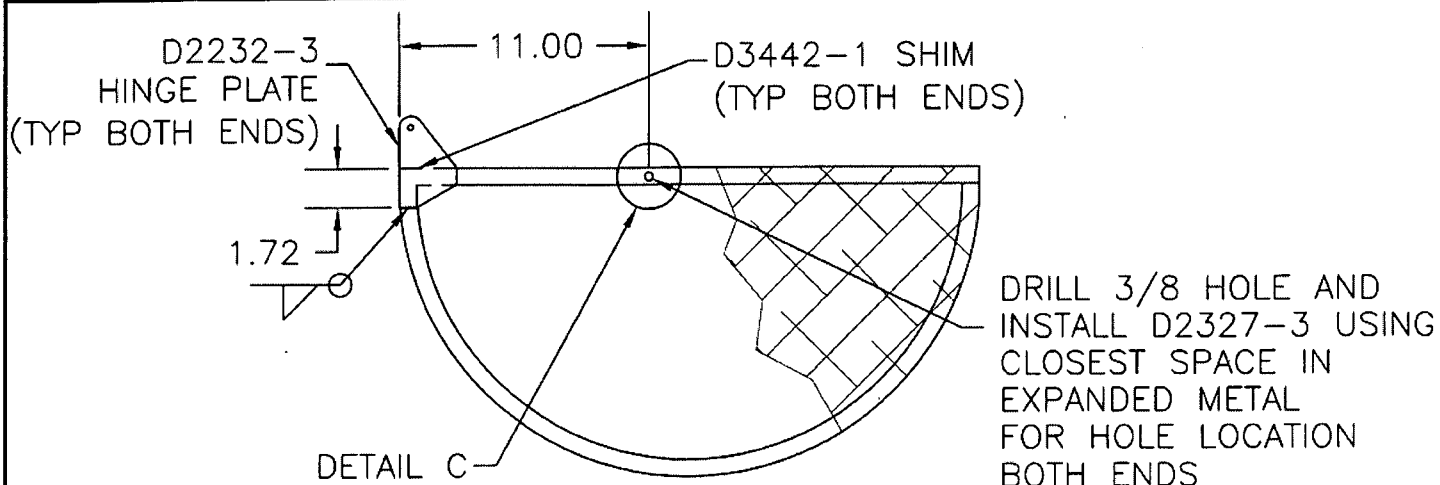
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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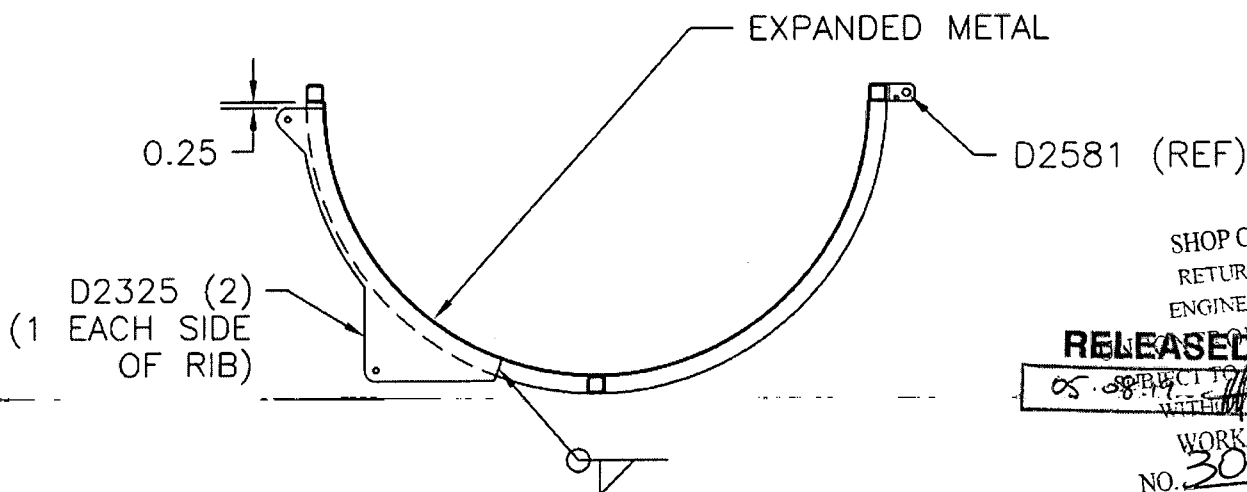
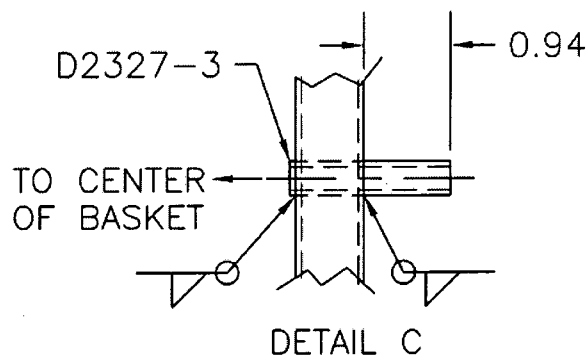
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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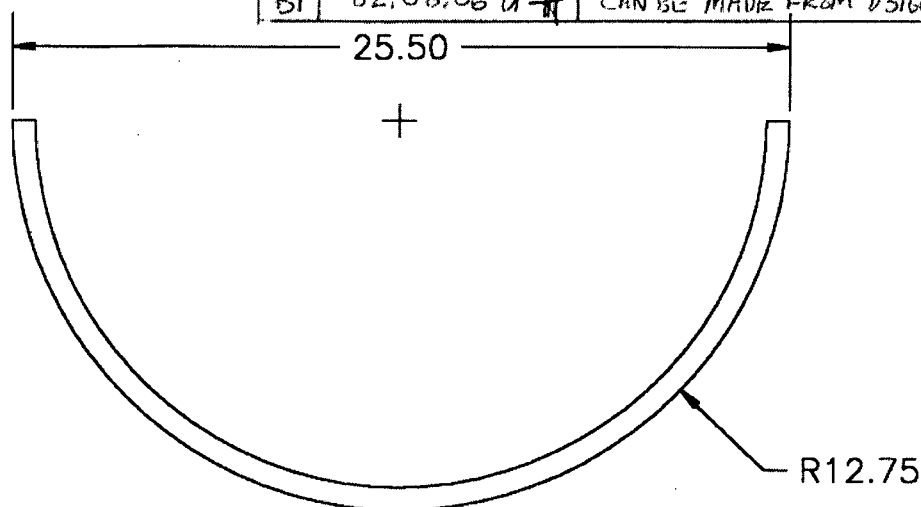
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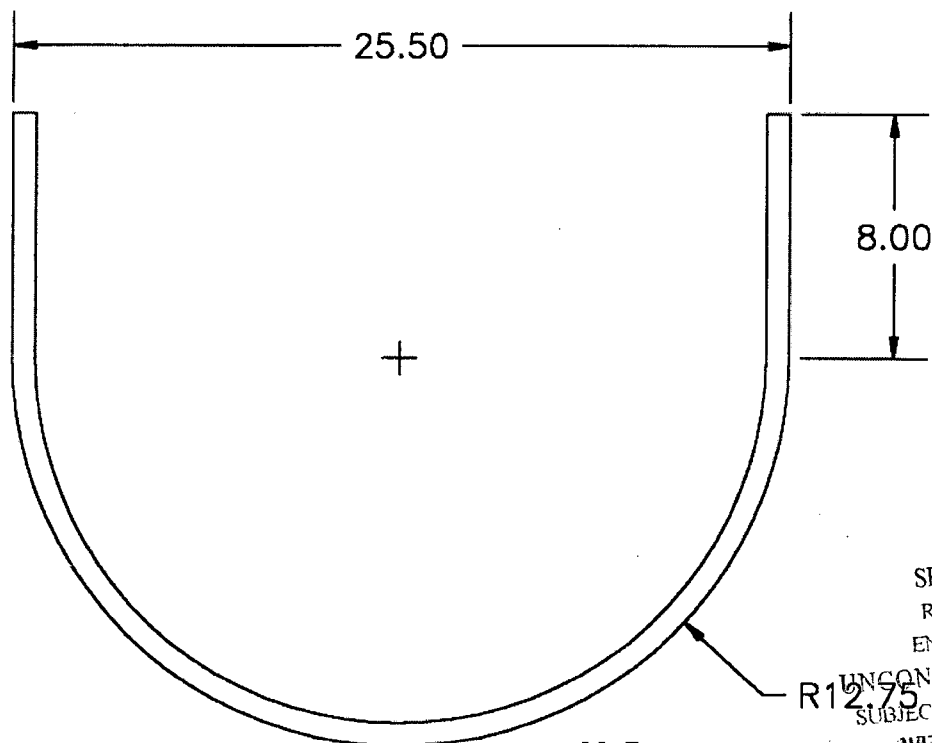


DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	
BI 02.08.06 <i>UPH</i>		CAN BE MADE FROM D3166-1	


RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WORK ORDER
NO. 30525A

Date: Wednesday, 1/31/2007 2:45:19 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 30525B		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 1/31/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2512 REV D2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30524B	Drawing Revision	: D2
		Material	: N/A
Written By	:	Due Date	: 2/28/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 46 f(s)/Unit Total : 46 f(s)
Pick:
3/4"x3/4" 304/316 SS tube .063" wall
Batch: M103701

Plc 07-03-19

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick:
Qty Part Number Description Batch
1 D3166-3 Basket Hoop B30144

Plc 07-03-19

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick:
Qty Part Number Description Batch
1 D2506 Label Plate B30548

Plc 07-03-19

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:
Qty Part Number Description Batch
2 D2327-1 Bushing B28334

Plc 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:45:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 30525B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D22321

Hinge



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Pick:

Qty Part Number Description

2 D2232-1 Hinge plate

Batch

825238

Pl 07.03.19

6.0

D2581

Mounting Bracket



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Pick:

Qty Part Number Description

2 D2581 Mounting Bracket

Batch

830003

Pl 07.03.19

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18 sf(s)/Unit Total: 18 sf(s)

Pick:

Qty Part Number Description

18 sf M304EX0.75-16F Expanded Metal

Batch

11103645

Pl 07.03.19

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

Pl 07.03.19

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 07/03/20

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11 07/03/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 07/03/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:45:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 30525B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



M1103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.h

07/03/24

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m.h

07/03/26



①

Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M103480

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m.h

07-03-27 ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m.h 07-03-27 ①

15.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

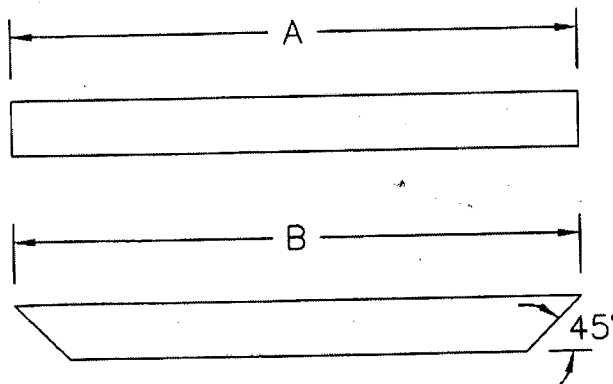


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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		UP 03.01.20	ADD D2012-117 FOR D130-701-041
D2		UP 04.09.20	TACK WELD ANT-SKID AREA

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4" X 3/4" X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

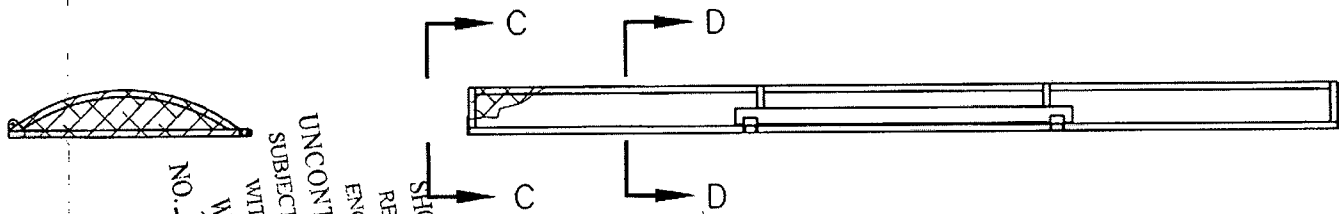
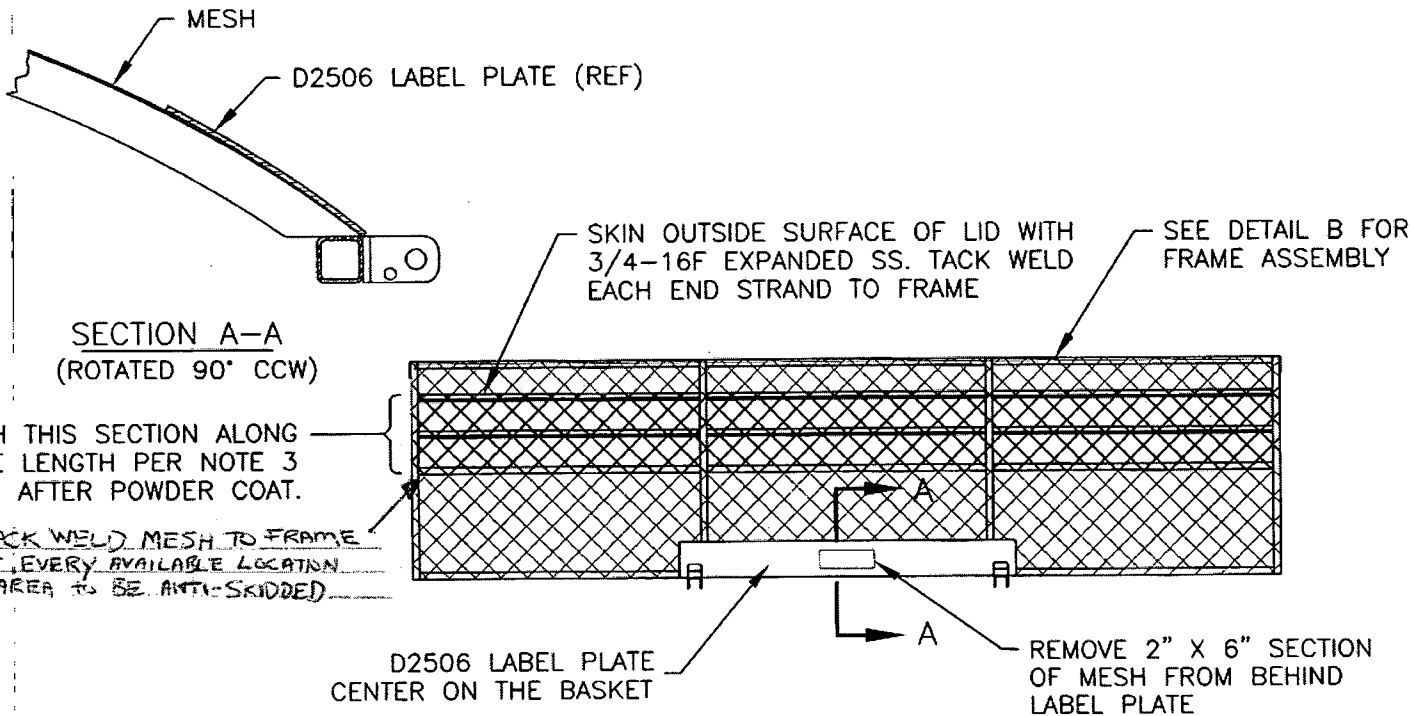
ALL DIMENSIONS ARE IN INCHES

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DATE	01.04.19	DRAWING NO.	D2512
		TITLE	BASKET LID ASSEMBLY (350/212)
		SCALE	1:20
		REV. D	SHEET 2 OF 4



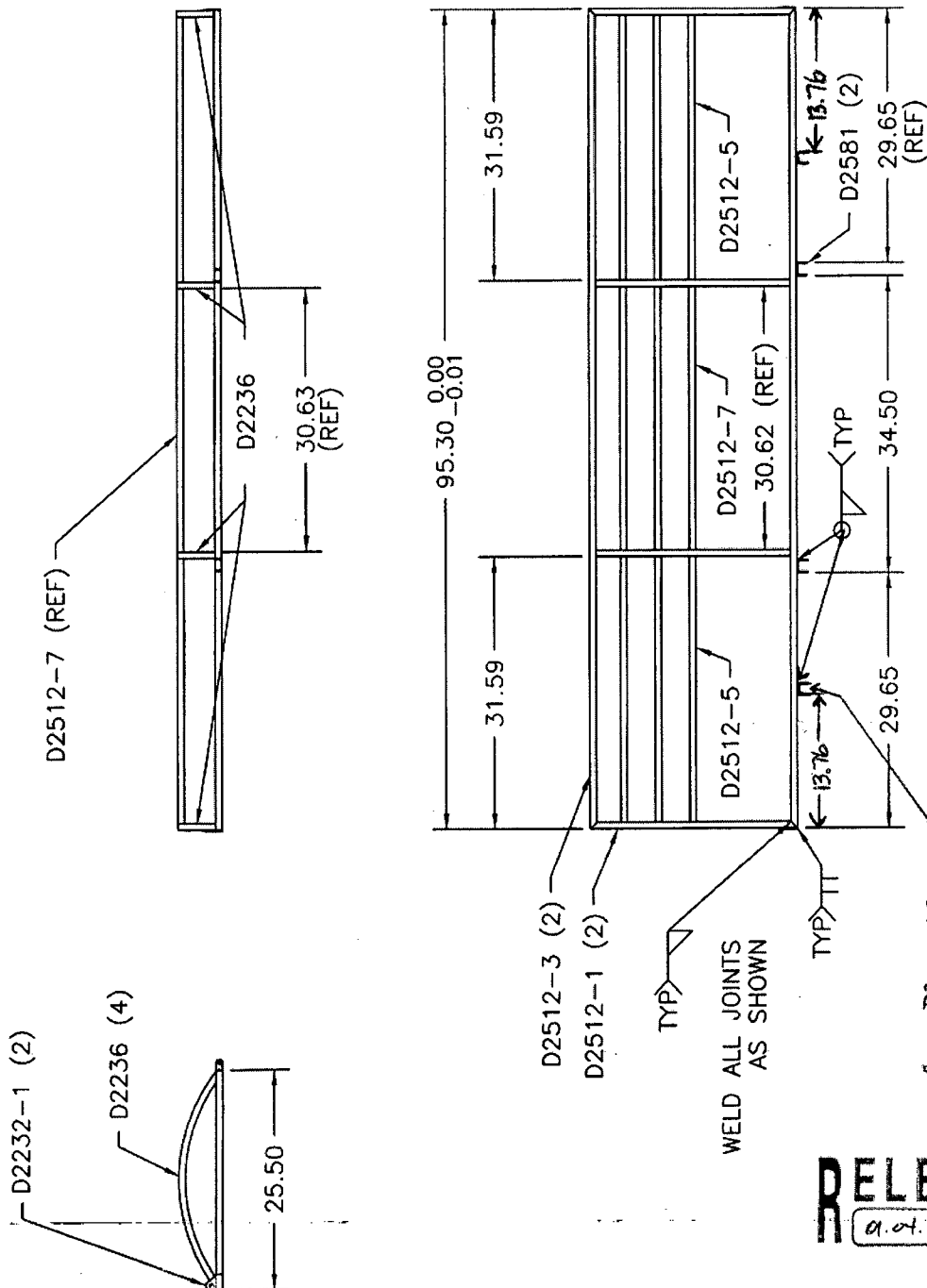
- D2512 BASKET LID ASSEMBLY**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
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DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEMS
ADD FOR D130-701-041
SUBJECT (2 PLACES)
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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 30525B

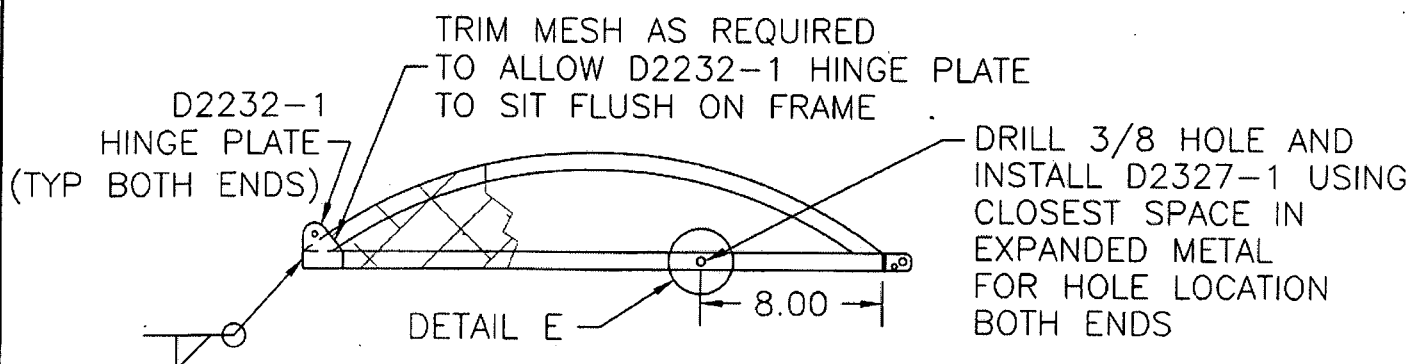
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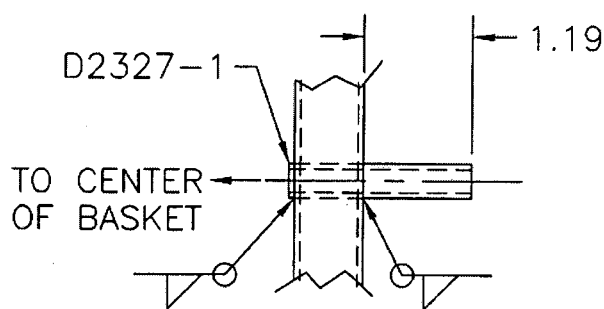
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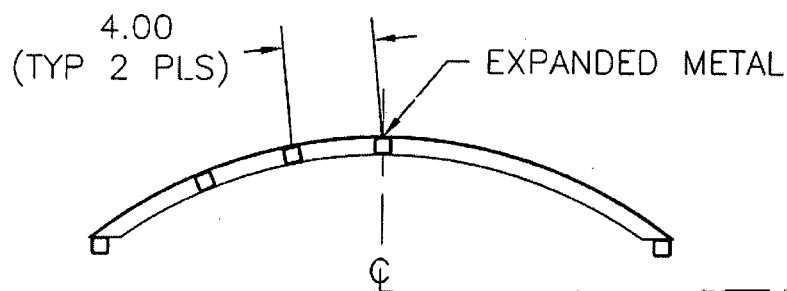
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DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



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DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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